

6645



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10884	50/50
3	Pallet Die No.		V.T.L. H/c Shop	Drill No. 12.0-31
4	Die Category	Drg. No.	10518 (G.O) H/c	Part 00
5	Out Side Diameter	Drg. No.	SSS10	
6	Inside Diameter	Drg. No.	6.81 H/c Step 00 - 6.84 H/c	Tapping 12
7	Width of Pellet Die	Drg. No.	5.20.12 H/c	Step length 14 H/c
8	Grooves as per Drawing	Drg. No.	1.86 H/c	Under cut 1.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	9x10x3 H/c 9x10x3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/A Shop	Tapping No. of Holes 12
13	Tapping Hole Diameter		5.65 H/c	Both Side
14	Tapping On Second Side	Half pitch of 1st side	NIG - Check by NIG Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 24.7 H/c	Tapping Depth 25 H/c
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 25/12/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.3 H/c	outside (23-3)		Inner					Part 18
3	External Relief Depth		4 H/c		Mill					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date				25	12	23			

Inspected By (Sign) & Date

Ravi 25/12/23

Ravi 25/12/23

Reviewed by (Engineer-CNC)

Manager-QA